

Date: Monday, 06/10/2008 10:44:40 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 02.750 SUPPORT
<b>Job Number</b> : 42440	
<b>Estimate Number</b> : 10829	
<b>P.O. Number</b> :	<b>Part Number</b> : D28931
<b>This Issue</b> : 06/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2893 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 42353	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 13/10/2008 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>2008-10-06</u>	
<b>Comment</b> : Est: C 02.11.26 Reformat; Added P/O KJ est D 06.04.19 removed alodine EC Est Rev:E Added priming as per Rev B 07-04-30 JLM est F 08.03.19 Re-format EC verified by: DD Est Rev:G 08-05-15 add QC14 DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DSK078	D2893-1 TURNING DETAIL



**Comment:** Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)  
 D2893-1 TURNING DETAIL  
 Batch: 42374

JL 08/11/17

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS 1  
 Machine as per Folio FA081  
 Tumble & Deburr

muc 08/11/18 JL 08/11/17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT ALL DIM TO DIM SHEET

muc 08/11/18 JL 08/11/17

4.0	QC8	SECOND CHECK
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(20)

**Comment:** SECOND CHECK

H.A 08/11/19

5.0	POWDER COATING	POWDER COATING
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(20X)

**Comment:** POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
 Mask Inside Bore for Priming

START TIME:

11:30

M-L 08/11/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 06/10/2008 10:44:40 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 42440

Part Number: D28931

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: *400*

FINISH TIME: *12-00*

*M-h 08/11/19*

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*(20)*

Comment: INSPECT POWDER COAT

*FZ 08/11/19*

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2893 and QSI 005 4.3.

*4T 08-12-18 (20)*

8.0

QC14

INSPECT SPRAY PAINT



*ml 08 12 18*



*(20)*

Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *x-tube Ass*

*ml 08 12 19*

*(20)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/12/22*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 08-12-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 472440
<b>Description:</b> Ø2.750 Support		<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		3.004	3.003	3.001	3.000	2.997
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		-.140	-.140	-.140	-.140	-.140
AD	0.040	0.060		.051	.051	.051	.051	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.157	.151	.149	.149	.151
AH	1.360	1.400		1.372	1.376	1.370	1.368	1.371
AI	0.040	0.060		.052	.047	.055	.047	.055
AJ	1.190	1.230		1.210	1.212	1.207	1.210	1.216
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.527	2.526	2.527	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L. Date: 08/11/15

Audited by: H.A. Date: 08/11/19

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42440
<b>Description:</b> Ø2.750 Support		<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.999	2.999	2.999	3.000	2.998
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.145	.140	.140	.140	.140
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.150	.152	.152	.153	.152
AH	1.360	1.400		1.375	1.373	1.373	1.372	1.375
AI	0.040	0.060		.054	.047	.046	.054	.046
AJ	1.190	1.230		1.216	1.211	1.209	1.215	1.211
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.526	2.527	2.526	2.527	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

**Measured by:** J.L. **Date:** 08/11/16

**Audited by:** M.A. **Date:** 08/11/17

**Prototype Approval:** **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42440
<b>Description:</b> Ø2.750 Support		<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893	<b>Rev:</b> B	<b>Page 1 of 1</b>

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AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.140	.140	.145	.140	.140
AD	0.040	0.060		.050	.050	.051	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.150	.151	.154	.153	.154
AH	1.360	1.400		1.371	1.371	1.370	1.372	1.375
AI	0.040	0.060		.053	.047	.055	.049	.054
AJ	1.190	1.230		1.214	1.209	1.215	1.212	1.218
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.525	2.526	2.528	2.527	2.526
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
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**Measured by:** J.L **Date:** 08/11/16

**Audited by:** H.A **Date:** 08/11/19

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AC	0.125	0.160		.140	.140	.145	.151	.145
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.140	.140	.140	.141	.142
AG	0.140	0.160		.154	.153	.153	.153	.152
AH	1.360	1.400		1.372	1.371	1.369	1.377	1.381
AI	0.040	0.060		.046	.045	.057	.055	.047
AJ	1.190	1.230		1.209	1.206	1.216	1.191	1.194
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.527	2.525	2.525	2.527	2.527
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

**Measured by:** J.L. [Signature] **Date:** 08/11/17 / 08/11/18

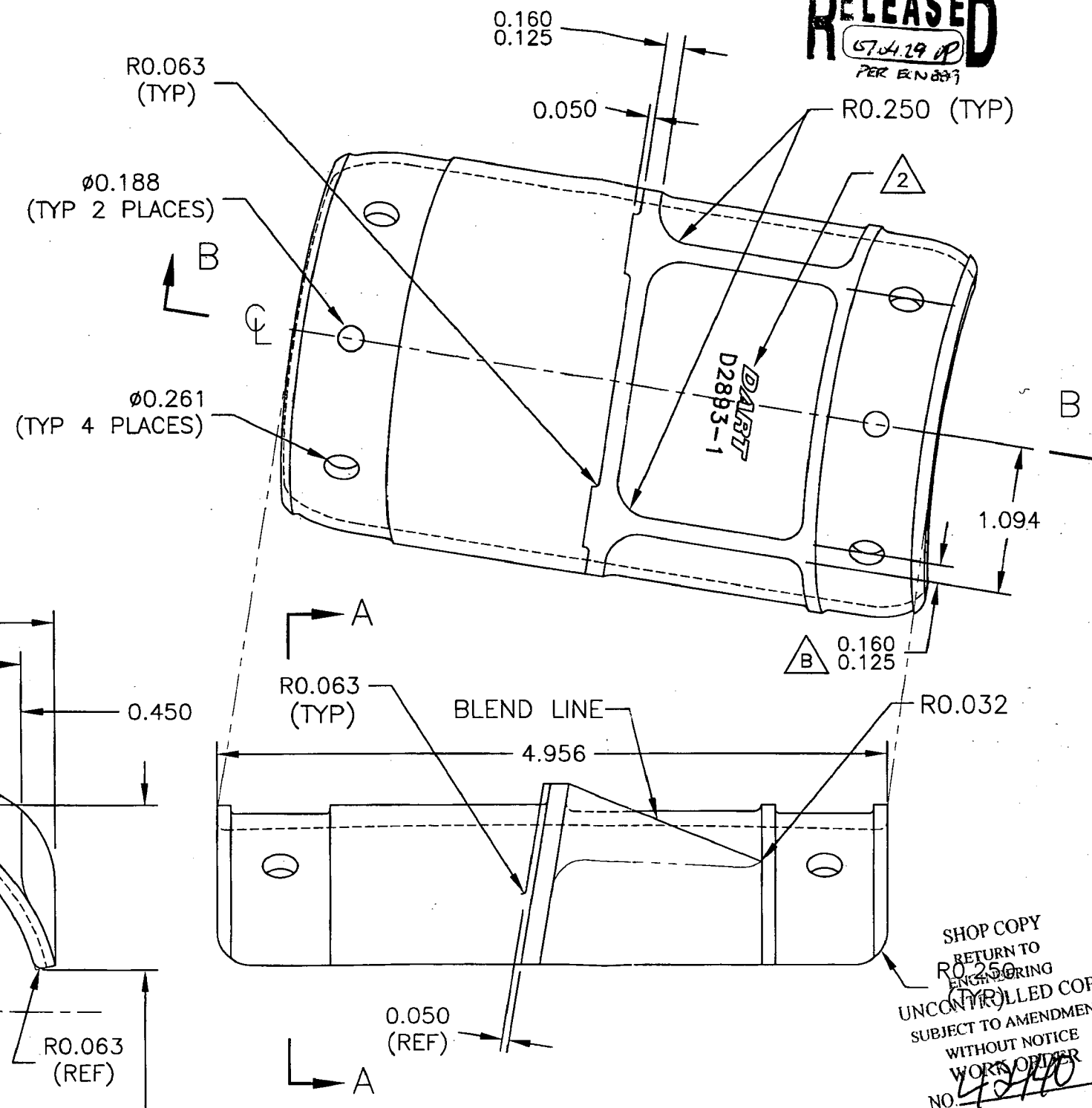
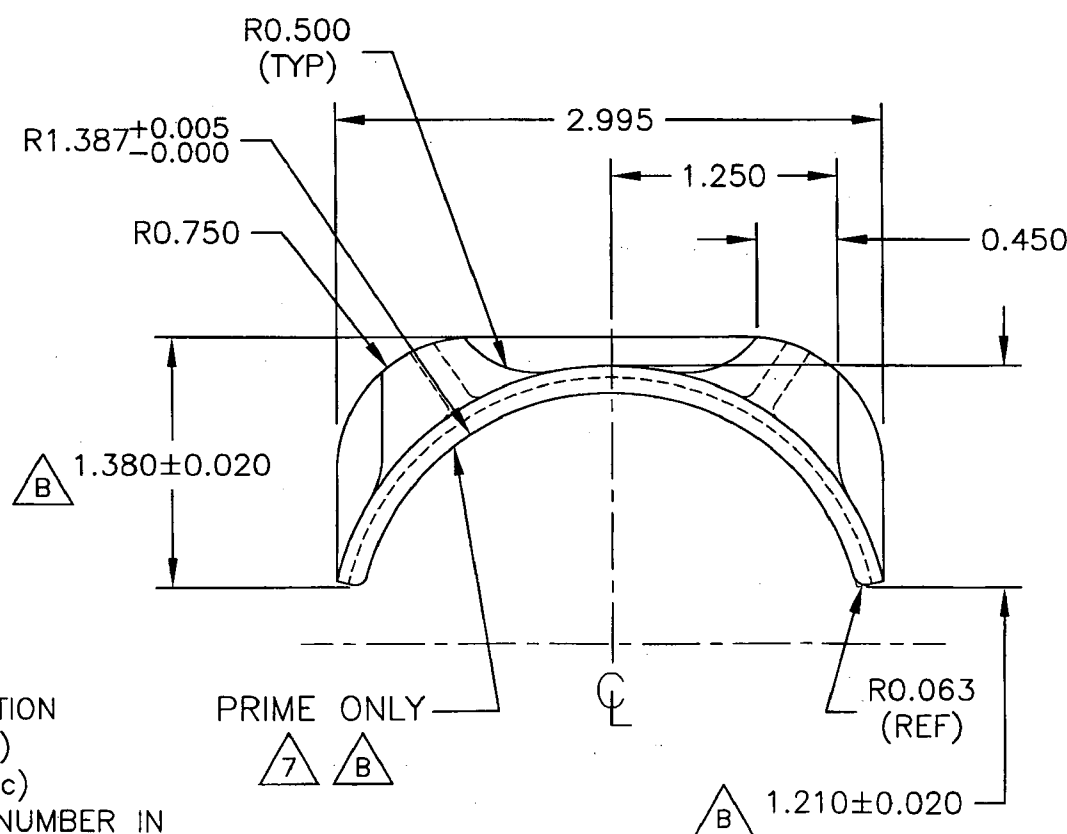
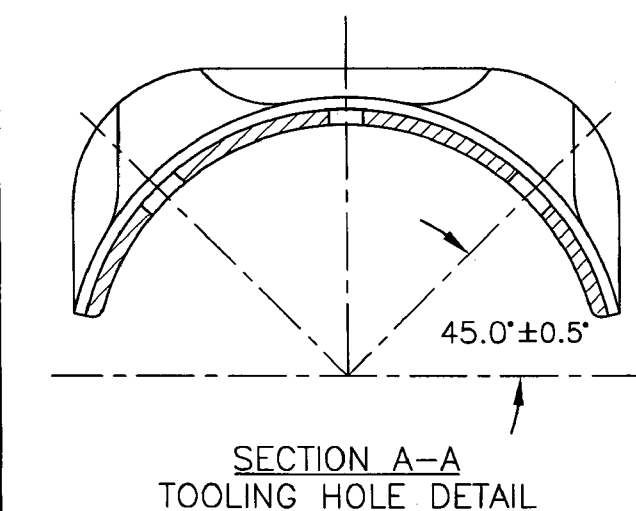
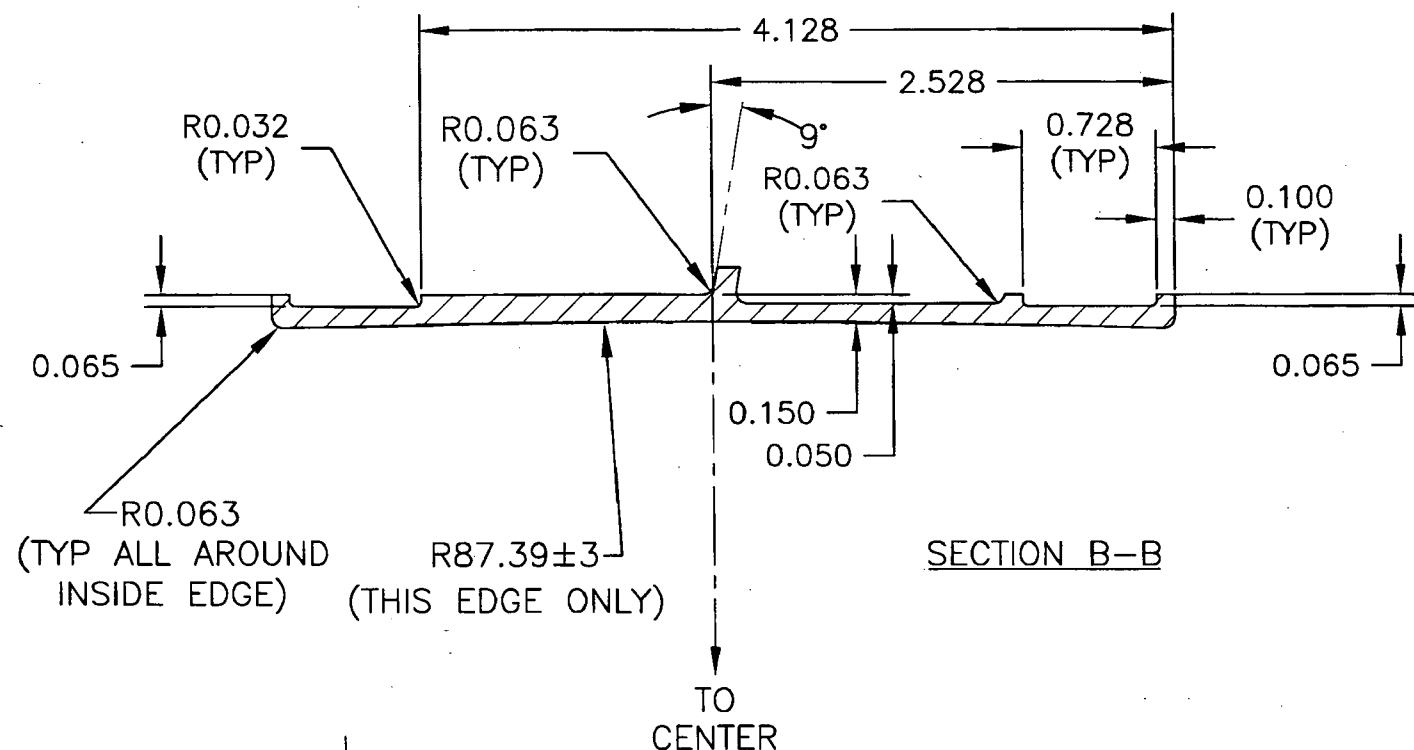
**Audited by:** H.A. **Date:** 08/11/19

**Prototype Approval:** **Date:**

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A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	[Signature]



**RELEASED**  
67.4.29.0P  
PER EN 883



**D2893-1**

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN  
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3  
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	GP	DRAWN BY PH
CHECKED	TH	APPROVED TH
DATE	07.03.16	TITLE
		02.750 SUPPORT
		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
		DRAWING NO. D2893
		REV. B
		SHEET 1 OF 1
		SCALE
		1:1

SHOP COPY  
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